

Date: Monday, 12/01/2009 2:30:08 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: SEAT FRAME ASSEMBLY				
<b>Job Number</b>	: 44556								
<b>Estimate Number</b>	: 11122								
<b>P.O. Number</b>	:				<b>Part Number</b>	: D3016041			
<b>This Issue</b>	: 12/01/2009		<b>S.O. No.</b>	:	<b>Drawing Number</b>	: D3016 REV A			
<b>Prsht Rev.</b>	: NC				<b>Project Number</b>	: N/A			
<b>First Issue</b>	: / /	<b>Type</b>	: LARGE FAB ASSY		<b>Drawing Revision</b>	: A			
<b>Previous Run</b>	: 43600				<b>Material</b>	:			
<b>Written By</b>	:				<b>Due Date</b>	: 30/01/2009			
<b>Checked &amp; Approved By</b>	: <u>JUL 09.01.12</u>				<b>Qty:</b>	1 Um: Each			
<b>Comment</b>	: Est. A 01.09.19 New issue EC								

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M4130NT0750W049	4130 RD Tube .750 x.049W	
		<b>Comment:</b> Qty.: 4.5150 f(s)/Unit Total : 4.5150 f(s) 4130 Tube .750 OD x.049W Cut:- AISI 4130N tube, Ø3/4" x 0.049" wall Batch: <u>M11642</u>	<i>LZ 9-6-18</i>
2.0	M4130NT1000W120	4130 RD Tube 1.00 x .120wall	
		<b>Comment:</b> Qty.: 1.5750 f(s)/Unit Total : 1.5750 f(s) 4130 Tube 1.0"D X 0.120"W batch <u>M108538</u>	<i>LZ 9-6-18</i>
3.0	M4130NT0500W049	4130 RD Tube .500 x.049W	
		<b>Comment:</b> Qty.: 4.5150 f(s)/Unit Total : 4.5150 f(s) 4130 Tube .500 OD x.049W Cut- AISI 4130N tube, Ø1/2" x 0.049" wall Batch: <u>M106651</u>	<i>LZ 9-6-18</i>
4.0	D301617	Gusset	
		<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Gusset Pick: Qty Part Number Description Batch	<i>EL 9-6-28</i>
	2	D3016-17 Gusset	<u>B39641</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:30:08 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT FRAME ASSEMBLY

Job Number: 44556

Part Number: D3016041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 D301613

Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket

Pick:

Qty	Part Number	Description	Batch
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2	D3016-13	Bracket	<u>1X B34208</u>
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1X B34208	1X B44778
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EL 9-6-22

6.0 D301615

Gusset



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Gusset

Pick:

Qty	Part Number	Description	Batch
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2	D3016-15	Gusset	<u>B43413</u>
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EL 9-6-22

7.0 D30201

Fitting



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Fitting

Pick:

Qty	Part Number	Description	Batch
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4	D3020-1	Fitting	<u>B36713</u>
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EL 9-6-22

8.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut all tubes as per Dwg D3016

2-Deburr

3-Assemble and weld as per Dwg D3016 using welding jig DT8597

A/R 4130 Rod Batch: M102226

4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041

EL 9-6-22

9.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

RF 9-6-23 i

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: SEAT FRAME ASSEMBLY

Job Number: 44556

Part Number: D3016041

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SO9/06/23 K/S/E/T

11.0 POWDER COATING POWDER COATING



M10404.1

Comment: POWDER COATING

Install paint screws on fitting ends

Powder Coat Grey sandtex (Ref. 4.3.5.6) as per QSI 005

START TIME: 11:30AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 12:00PM

41 09-04-24 K

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 09-06-24 ①

13.0 PACKAGING 1 PACKAGING RESOURCE #1



ax

SV

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

9/06/24

14.0 QC21 FINAL INSPECTION/W/O RELEASE



09/06/24 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C 209/06/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

**NOTES**

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

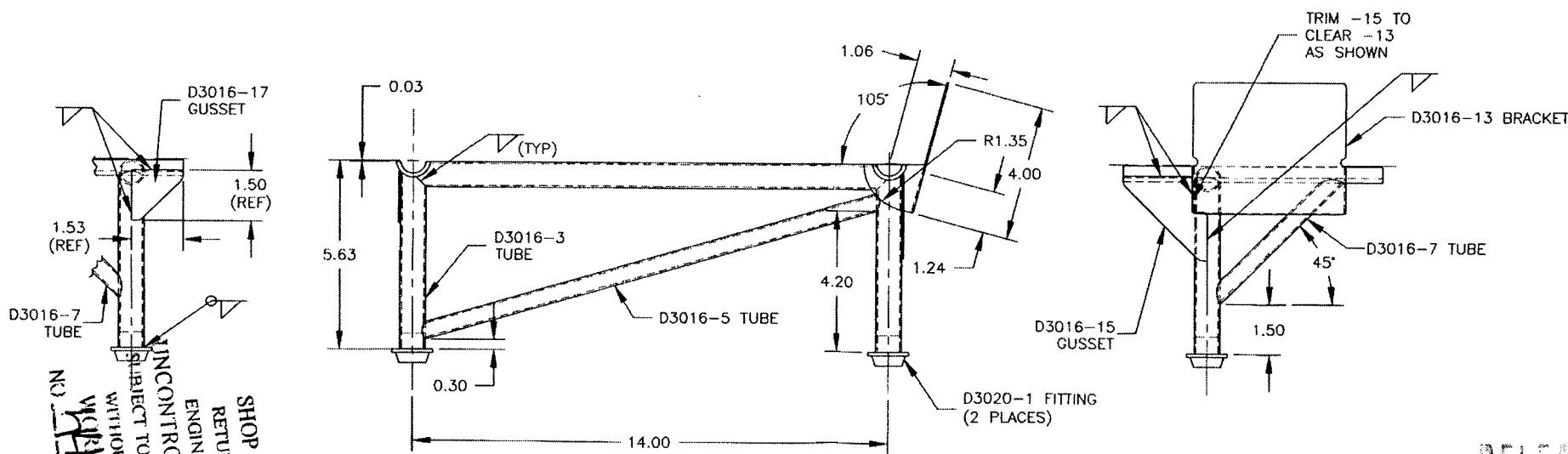
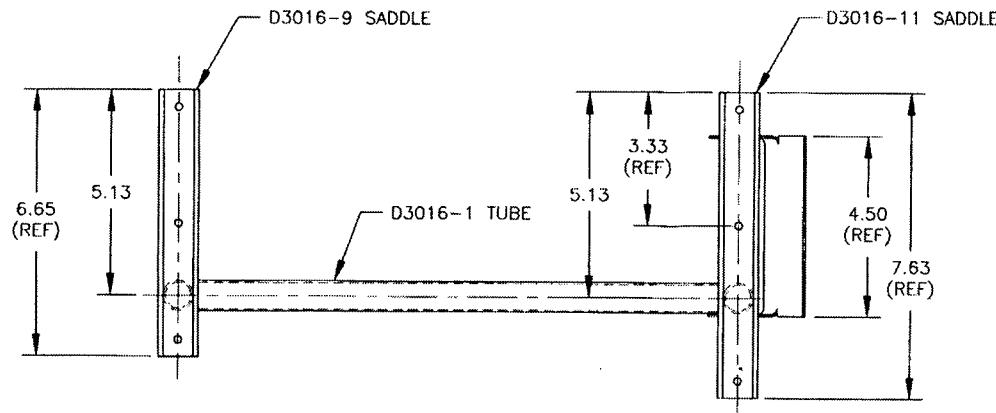
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D3016-041 SEAT FRAME ASSEMBLY



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DESIGN	DRAWN BY	DART AEROSPACE LTD. HANKEYBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3016
DATE		SHEET 2 OF 3
01.05.18		SCALE 1:3
		TITLE SEAT FRAME ASSEMBLY

RELEASED  
01.05.18

